

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008945**Date Inspected:** 27-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT selected areas previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as OBG 3AE. The weld designations reviewed are as follows:

3AE

1. Diaphragm to Floor Beam at panel point 19.

1AE

SMAW welding of weld joints 045~048 located on LD026.

Welder is identified as Mr. Luo Houkuan (067610). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

SMAW welding of weld joints 071~074 located on LD026.

Welder is identified as Mr. Luo Houkuan (067610). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

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SMAW welding of weld joints 071~074 located on LD026.

Welder is identified as Mr. Hao Jianxiang (067665). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

SMAW welding of weld joints 045~048 located on LD026.

Welder is identified as Mr. Hao Jianxiang (067665). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

1AAE & 1AE

SMAW welding (VT repair) of bottom plate stiffeners hold back welds.

Welder is identified as Mr. Liu Houkuan (045133). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair.

5BE & 5CE

SAW welding of weld splice joint 008 located on OBE5.

Welder is identified as Mrs. Cu Caihong (053748). ZPMC QC is identified as Gu Rong Jian.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2a-S-3.

SAW welding of weld splice joint 008 located on OBE5.

Welder is identified as Mrs. Mu Jing Fen (054458). ZPMC QC is identified as Gu Rong Jian.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2a-S-3.

SMAW welding of weld splice joint 008 located on OBE5.

Welder is identified as Mr. Du Hengyon (037743). ZPMC QC is identified as Gu Rong Jian.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231T.

FCAW welding of weld splice joint 006 located on OBE5A.

Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231T.

FCAW welding of weld splice joint 006 located on OBE5A.

Welder is identified as Mr. Li Xuehua (200676). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231T.

1BE

SMAW welding (VT repair) of bottom plate stiffeners hold back welds.

Welder is identified as Mr. Han Xiao Feng (054467). ZPMC QC is identified as Gu Rong Jian.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
